

Work Order ID 52592

Page 1

October 2, 2009 11:20:19 AM

Item ID: D3121-241

Accept



Setup Start



Revision ID: E

Stop



Item Name: Bearing Assembly

93

Start Date: 02/10/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 20/10/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals:	Process Plan:	<i>RS</i>	Date: 09-10-2	Tooling:		Date:	Run Start			
	QC:		Date:	SPC (Y/N):		Date:	Stop			

Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	--	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D3121	Rev E	

100



Hardinge CNC LATHE SMALL

0.00

RS 09/10/11

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Turn D3121-25 Cap as per Folio FA387 □2-Deburr

110



QC2- Inspect parts off machine FAI/FAIB

0.00

RS 09/10/11

QC

Memo

0.00

Quality Control

120



QC8- Inspect parts - second check

0.00

RS 09. 10 . 15

QC

Memo

0.00

Quality Control

RS 09/10/11
RS 09/10/11
RS 09/10/11

Work Order ID 52592

Page 2

October 2, 2009 11:20:19 AM

Item ID: D3121-241

Accept



Setup Start



Revision ID: E

Stop



Item Name: Bearing Asserably

Start Date: 02/10/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 20/10/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop


**Sequence ID/
Work Center ID**
**Operation
Description**
**Set Up/
Run Hours**
**Draw
Number**
**Draw
Rev.**
**Plan
Code**
**Accept
Qty**
**Reject
Qty**
**Reject
Number**
**Insp.
Stamp**

130



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab 1-Press D3121-23 Bearing into D3121-25 Cap as per Dwg D3121

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: 23SA

0.00

Packaging

Memo

0.00

Packaging

Work Order ID 52592

Page 3

October 2, 2009 11:20:19 AM

Item ID: D3121-241

Accept



Setup Start



Revision ID: E

Stop



Item Name: Bearing Assembly

Start Date: 02/10/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 20/10/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

09/10/19 JJ

MF
09-10-19

Picklist Print

October 2, 2009 11:20:19 AM

Page 1
1

Work Order ID: 52592



Parent Item: D3121-241RevE



Parent Item Name: Bearing Assembly

Start Date: 02/10/2009

Required Date: 20/10/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3121-23RevE Manufactured No 100 Each 241.0000 40.0000



Bearing

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 241

46850 11

46963 2C

47676 200

2009/10/16

MDELRINR1.2500 Purchased No 130 f 16.2200 2.1895



DELRIN ROUND BAR 1.25"

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT 16.22

110256 16.22

4P 2109/10/11

DART AEROSPACE LTD	Work Order:	52592
Description: Cap	Part Number:	D3121-25
Inspection Dwg: D3121 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

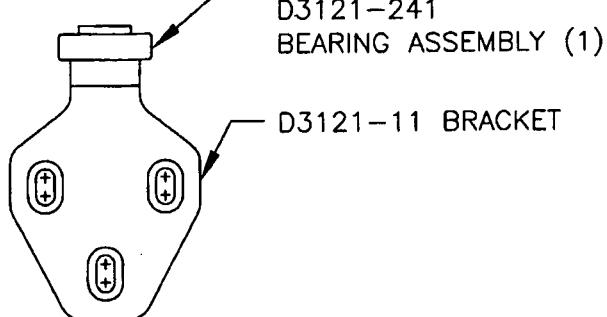
X First Article Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	03/10/11	Date:	09.10.15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D3121-241)	KJ/RF	
B	06.06.09	Ø1.000 diameter was Ø1.024	KJ/JLM	
C	08.01.16	Dwg Rev. updated	KJ/EC/DD	

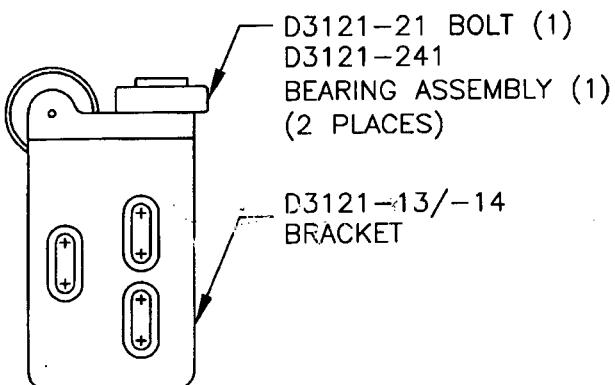
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DATE 07.11.07		REV. E SHEET 1 OF 10 TITLE SCALE 1:2 BRACKET ASSEMBLY

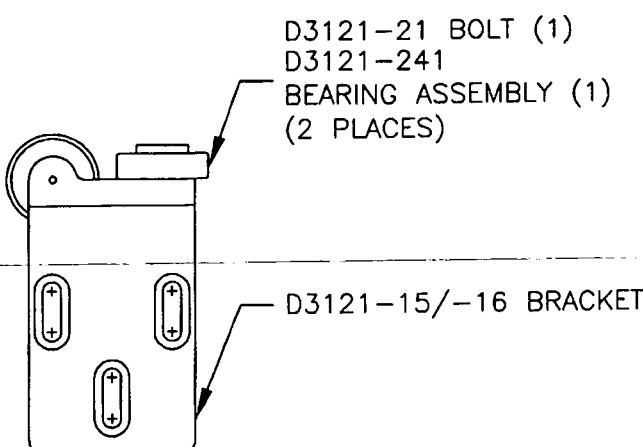
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D3121-041 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-33)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED CO¹
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *52592*
B1 09-10-2



D3121-043 (SHOWN) / D3121-044 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-37/-38)



D3121-045 (SHOWN) / D3121-046 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-35/-36)

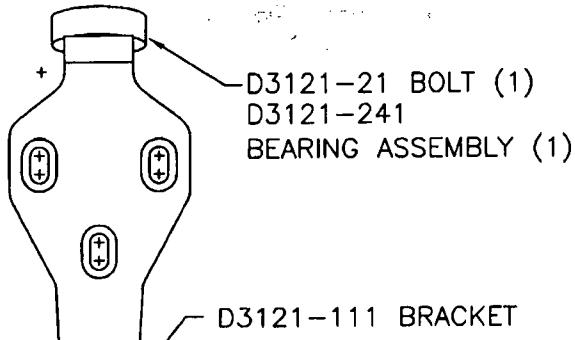
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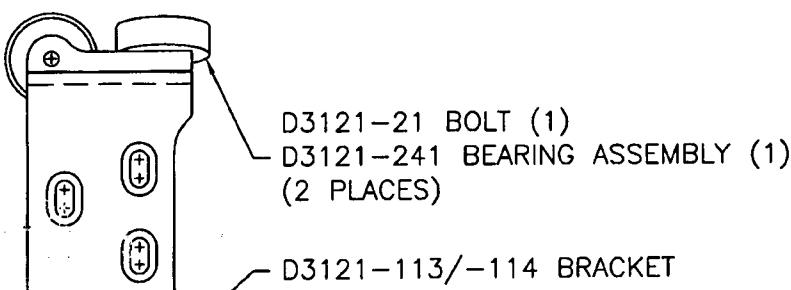
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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

w/o 52592 Br

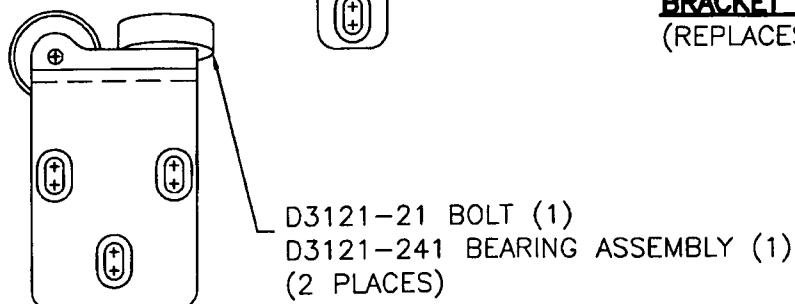


D3121-141 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23001-01)

RELEASED
07.11.07 W



**D3121-143 (SHOWN) / D3121-144 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-03/-04)



**D3121-145 (SHOWN) / D3121-146 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-05/-06)

D3121-115/-116
BRACKET

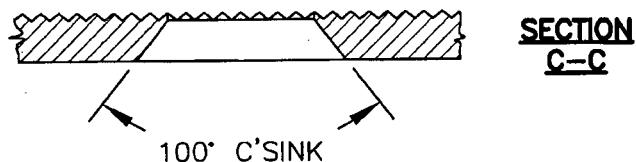
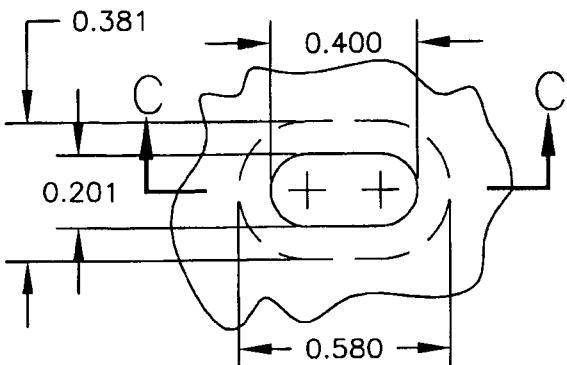
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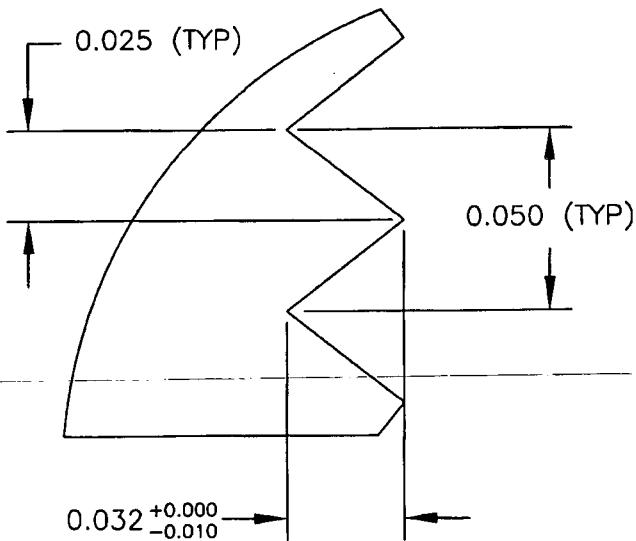
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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

DETAIL A:
SLOT DETAIL
SCALE 2:1
VIEW ROTATED



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DETAIL B:
RIDGE DETAIL
PARTIAL SECTION
SCALE 1:20

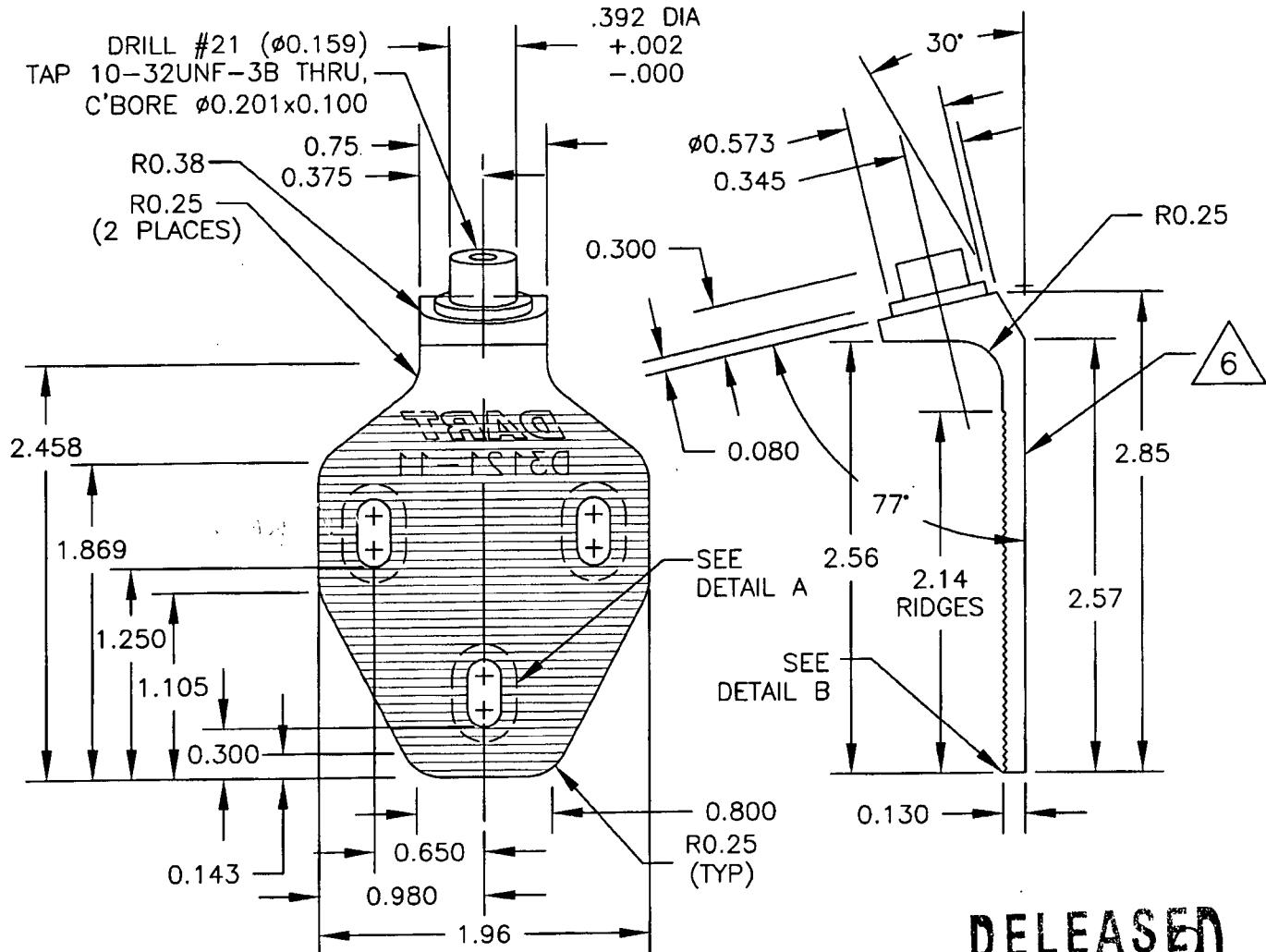


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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1



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07.11.07 *[Signature]*

D3121-11 BRACKET

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

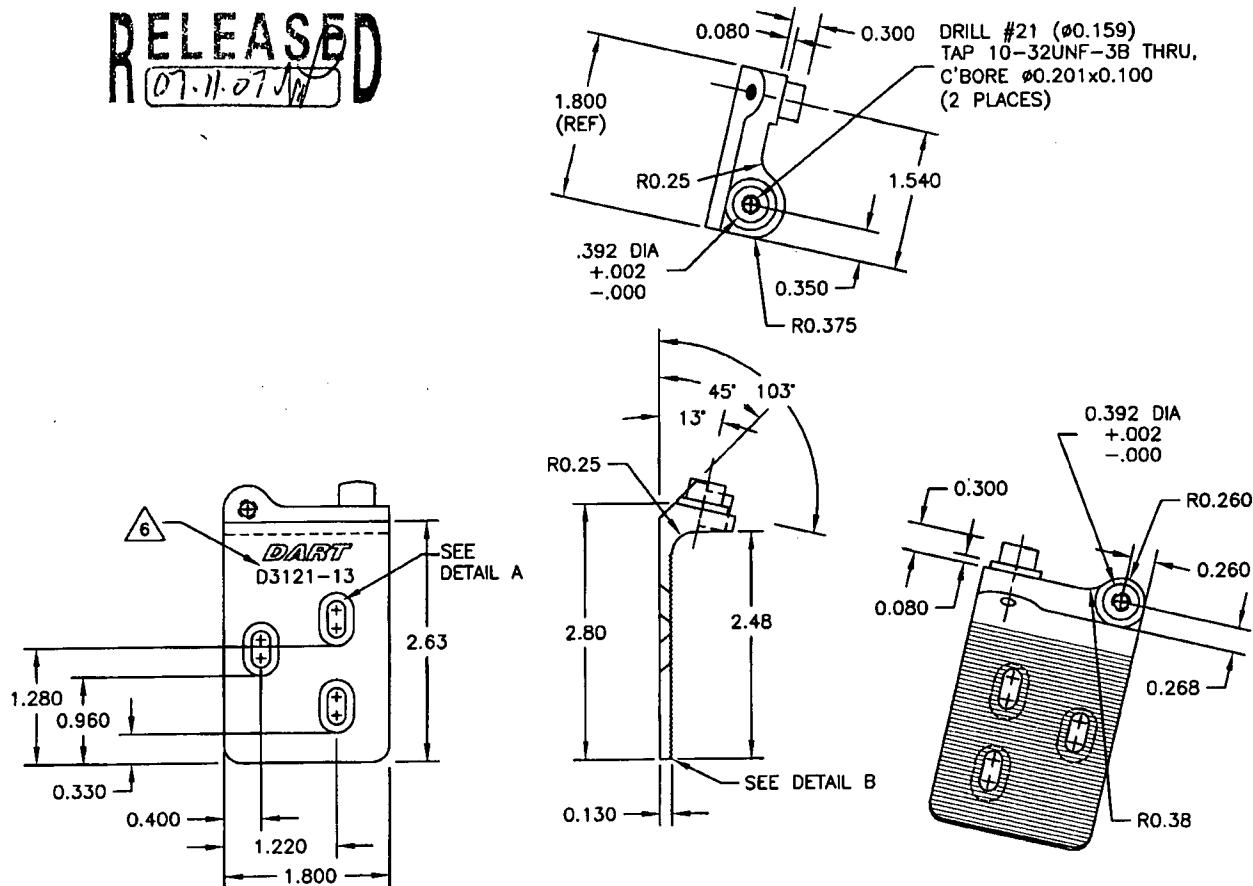
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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
(07.11.07)



D3121-13 BRACKET (SHOWN)

D3121-14 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

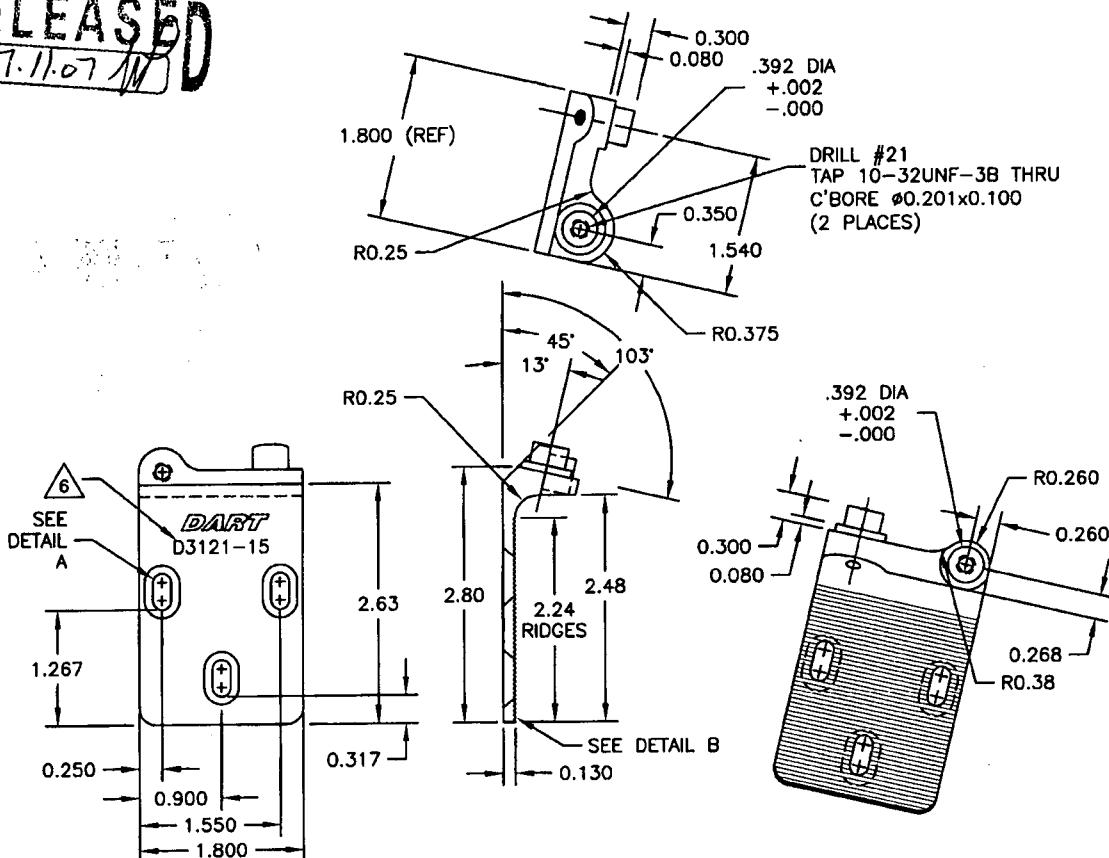
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07.11.07



D3121-15 BRACKET (SHOWN)

D3121-16 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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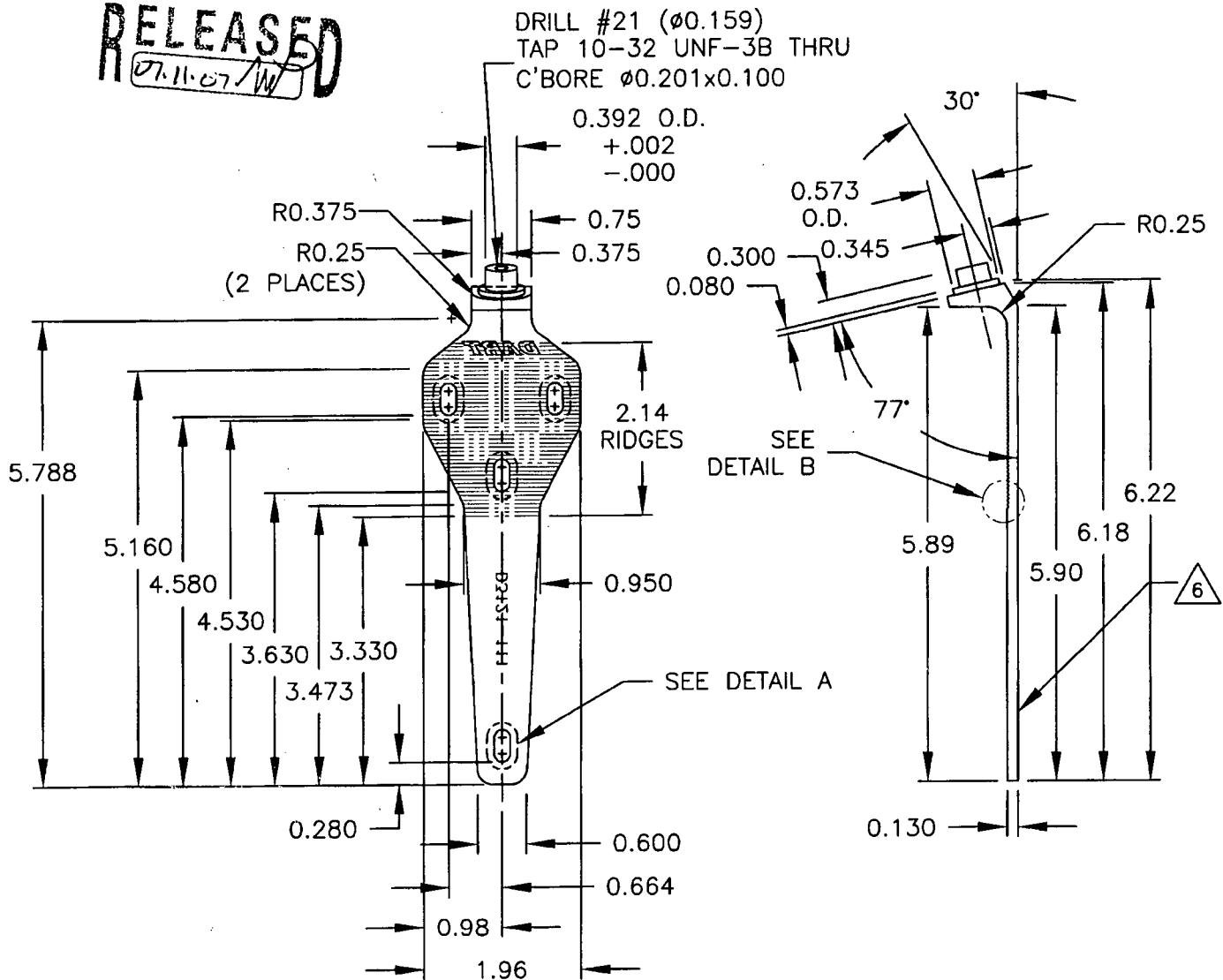
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DATE		REV. E SHEET 7 OF 10 TITLE SCALE 1:2

w/o 52592 D

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07.11.07/W



D3121-111 BRACKET

- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

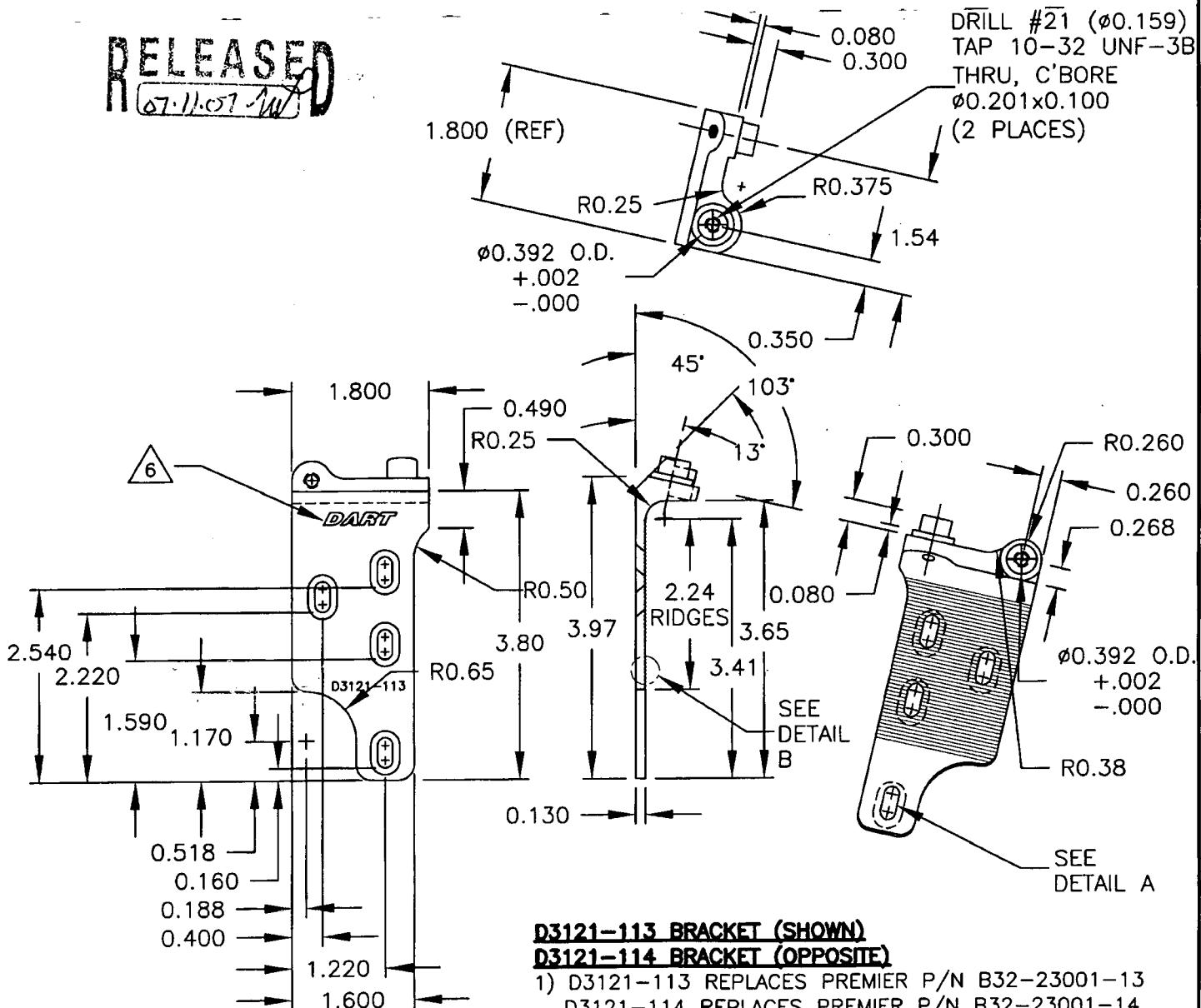
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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

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07.11.07 *WJ*



D3121-113 BRACKET (SHOWN)
D3121-114 BRACKET (OPPOSITE)

- 1) D3121-113 REPLACES PREMIER P/N B32-23001-13
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN. ULTIMATE TENSILE STRENGTH = 150 ksi
MIN. YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

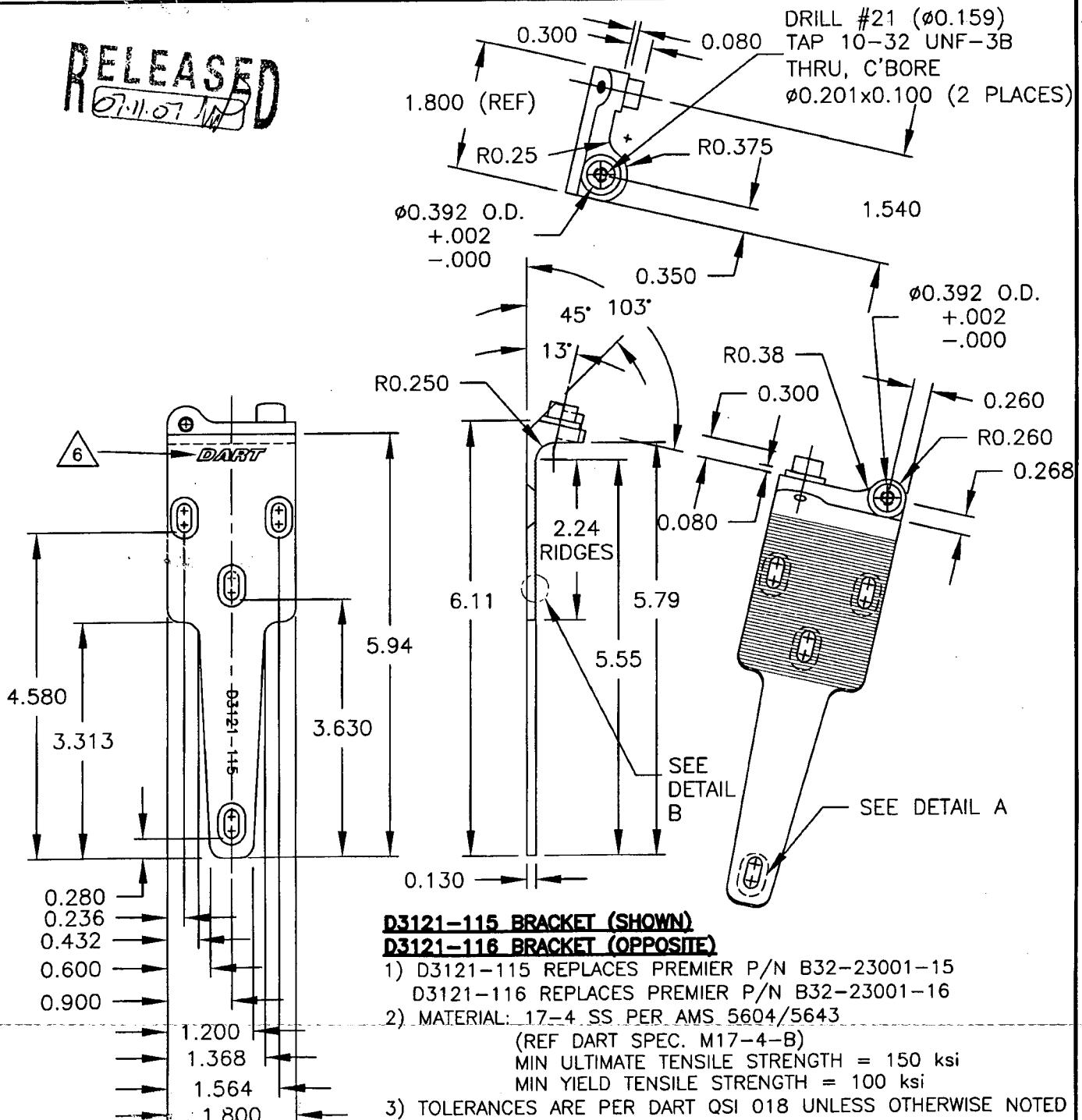
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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

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07.11.07 M

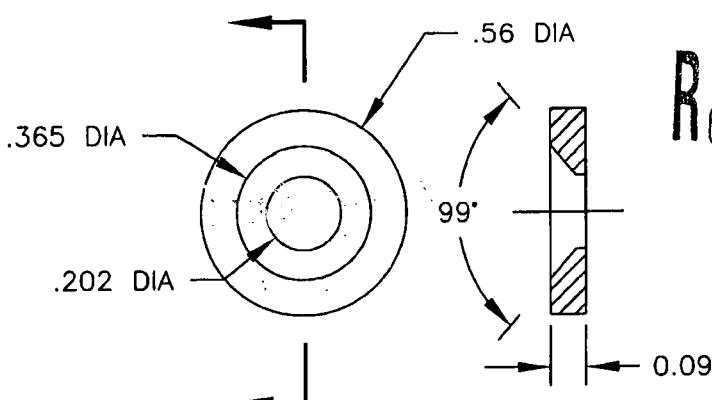


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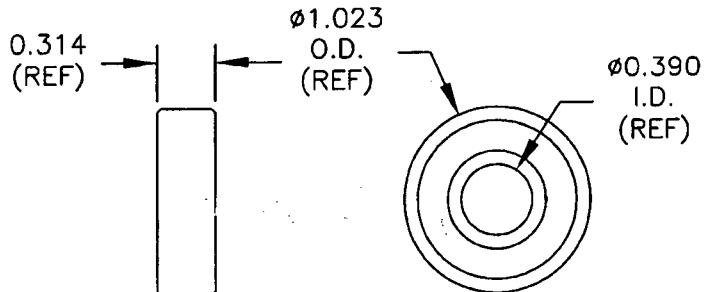
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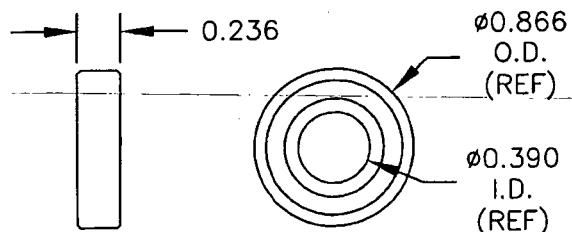
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CHECKED <i>A</i>	APPROVED <i>H</i>	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

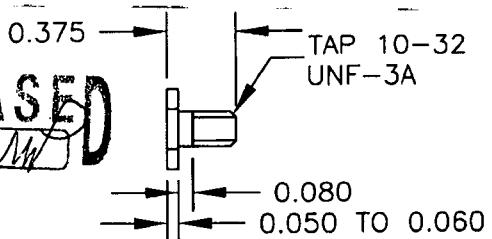
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

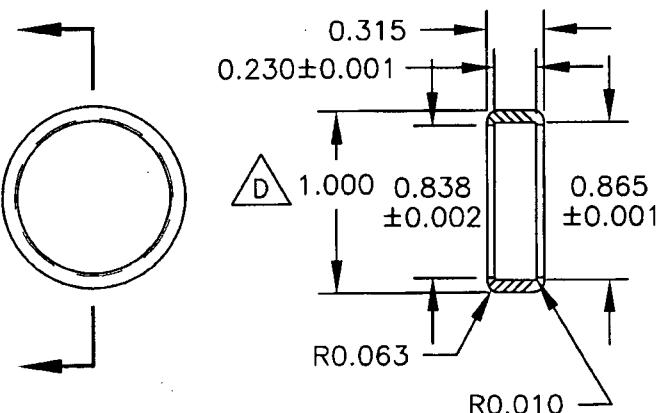
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM
FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

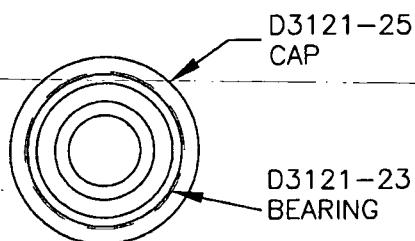
- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z
OR KML P/N 6900-2Z
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**